



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2580-1****Job Sheet 197167****Part No:** D2580-1**Job Qty:** 8 pcs**Part Name:** 205 Bent Tube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/2/19**Job Tracking No:****Due Date:** 7/26/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

**Note:** DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01  
as per DEO D1 DD ver:fec

**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off |
|-------|-------------------------------|-------|------------|----------|-----------|---------|--------------------------|-----------|----------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |          |
| 100   | Skidtubes - 1                 | 8 pcs | 7/26/19    |          | 0.00      | 7.41    | Skidtubes - 1            |           | TF       |
|       |                               |       |            |          |           |         | Skidtubes - 2            |           |          |
|       |                               |       |            |          |           |         | Skidtubes - 3            |           |          |
|       |                               |       |            |          |           |         | Skidtubes - 4            |           |          |
|       |                               |       |            |          |           |         | Skidtubes - 5            |           |          |
|       |                               |       |            |          |           |         | Skidtubes - 6            |           |          |
|       |                               |       |            |          |           |         | Skidtubes - 7            |           |          |
| 101   | QC 5                          | 8 pcs | 7/26/19    |          | 0.00      | 0.00    | QC 5 - 10                |           | BE       |
|       |                               |       |            |          |           |         | QC 5 - 12                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 17                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 18                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 19                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 22                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 24                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 3                 |           |          |
|       |                               |       |            |          |           |         | QC 5 - 43                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 49                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 51                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 58                |           |          |
|       |                               |       |            |          |           |         | QC 5 - 68                |           |          |
| 110   | Handfinish - 1-1 Chemical-B4B | 8 pcs | 7/26/19    |          | 0.00      | 3.33    | Handfinish - 1 - 1 - B4B |           |          |
|       |                               |       |            |          |           |         | Handfinish - 1 - 2 - B4B |           |          |
|       |                               |       |            |          |           |         | Handfinish - 1 - 3 - B4B |           |          |
|       |                               |       |            |          |           |         | Handfinish - 1 - 4 - B4B |           |          |
|       |                               |       |            |          |           |         | Handfinish - 1 - 5 - B4B |           |          |
|       |                               |       |            |          |           |         | Handfinish - 1 - 6 - B4B |           |          |



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1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Container No:** S198058**Part:** D2580-1**Job No:** 197167**Serial No/Batch:** S198058**Revision:** H**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 07/15/19

|                         |       |         |           |                           |    |
|-------------------------|-------|---------|-----------|---------------------------|----|
|                         |       |         |           | Handfinish - 1 - 7 - B4B  |    |
|                         |       |         |           | Handfinish - 1 - 8 - B4B  |    |
|                         |       |         |           | Handfinish - 1 - 9 - B4B  |    |
|                         |       |         |           | Handfinish - 1 - 10 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 11 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 12 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 13 - B4B | 3y |
|                         |       |         |           | Handfinish - 1 - 14 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 15 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 16 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 17 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 18 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 19 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 20 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 21 - B4B |    |
|                         |       |         |           | Handfinish - 1 - 22 - B4B |    |
| 120 QC 7                | 8 pcs | 7/26/19 | 0.00 0.00 | QC 7 - 10                 |    |
|                         |       |         |           | QC 7 - 13                 |    |
|                         |       |         |           | QC 7 - 14                 |    |
|                         |       |         |           | QC 7 - 15                 |    |
|                         |       |         |           | QC 7 - 17                 |    |
|                         |       |         |           | QC 7 - 18                 | BE |
|                         |       |         |           | QC 7 - 19                 |    |
|                         |       |         |           | QC 7 - 2                  |    |
|                         |       |         |           | QC 7 - 28                 |    |
|                         |       |         |           | QC 7 - 3                  |    |
|                         |       |         |           | QC 7 - 30                 |    |
|                         |       |         |           | QC 7 - 34                 |    |
|                         |       |         |           | QC 7 - 36                 |    |
|                         |       |         |           | QC 7 - 37                 |    |
|                         |       |         |           | QC 7 - 41                 |    |
|                         |       |         |           | QC 7 - 47                 |    |
|                         |       |         |           | QC 7 - 48                 |    |
|                         |       |         |           | QC 7 - 51                 |    |
|                         |       |         |           | QC 7 - 58                 |    |
|                         |       |         |           | QC 7 - 59                 |    |
|                         |       |         |           | QC 7 - 60                 |    |
|                         |       |         |           | QC 7 - 9                  |    |
|                         |       |         |           | QC 7 - 68                 |    |
|                         |       |         |           | QC 7 - 50                 |    |
|                         |       |         |           | QC 7 - 67                 |    |
|                         |       |         |           | QC 7 - 40                 |    |
|                         |       |         |           | QC 7 - 24                 |    |
|                         |       |         |           | QC 7 - 43                 |    |
|                         |       |         |           | QC 7 - 61                 |    |
|                         |       |         |           | QC 7 - 81                 |    |
| 125 Skidtubes - 2 - B4B | 8 pcs | 7/26/19 | 0.00 7.41 | Skidtubes - 1 - B4B       | 00 |
|                         |       |         |           | Skidtubes - 2 - B4B       |    |



|     |                             |          |         |                     |                        |
|-----|-----------------------------|----------|---------|---------------------|------------------------|
|     |                             |          |         | Skidtubes - 3 - B4B |                        |
|     |                             |          |         | Skidtubes - 4 - B4B |                        |
|     |                             |          |         | Skidtubes - 5 - B4B |                        |
|     |                             |          |         | Skidtubes - 6 - B4B |                        |
|     |                             |          |         | Skidtubes - 7 - B4B |                        |
| 130 | QC 5                        | 8<br>pcs | 7/26/19 | 0.00 0.00           | QC 5 - 10              |
|     |                             |          |         |                     | QC 5 - 12              |
|     |                             |          |         |                     | QC 5 - 17              |
|     |                             |          |         |                     | QC 5 - 18              |
|     |                             |          |         |                     | QC 5 - 19              |
|     |                             |          |         |                     | QC 5 - 22              |
|     |                             |          |         |                     | QC 5 - 24              |
|     |                             |          |         |                     | QC 5 - 3               |
|     |                             |          |         |                     | QC 5 - 43              |
|     |                             |          |         |                     | QC 5 - 49              |
|     |                             |          |         |                     | QC 5 - 51              |
|     |                             |          |         |                     | QC 5 - 58              |
|     |                             |          |         |                     | QC 5 - 68              |
|     |                             |          |         |                     | QC 5 - 9               |
|     |                             |          |         |                     | QC 5 - 50              |
|     |                             |          |         |                     | QC 5 - 30              |
|     |                             |          |         |                     | QC 5 - 40              |
| 140 | Packaging 3-1 - Stock - B4B | 8<br>pcs | 7/26/19 | 0.00 0.00           | Packaging 3 - 1 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 2 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 3 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 4 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 5 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 6 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 7 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 8 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 9 - B4B  |
|     |                             |          |         |                     | Packaging 3 - 10 - B4B |
|     |                             |          |         |                     | Packaging 3 - 11 - B4B |
|     |                             |          |         |                     | Packaging 3 - 12 - B4B |
|     |                             |          |         |                     | Packaging 3 - 13 - B4B |
|     |                             |          |         |                     | Packaging 3 - 14 - B4B |
|     |                             |          |         |                     | Packaging 3 - 15 - B4B |
|     |                             |          |         |                     | Packaging 3 - 16 - B4B |
|     |                             |          |         |                     | Packaging 3 - 17 - B4B |
|     |                             |          |         |                     | Packaging 3 - 18 - B4B |
|     |                             |          |         |                     | Packaging 3 - 19 - B4B |
|     |                             |          |         |                     | Packaging 3 - 20 - B4B |
|     |                             |          |         |                     | Packaging 3 - 21 - B4B |
|     |                             |          |         |                     | Packaging 3 - 22 - B4B |
|     |                             |          |         |                     | Packaging 3 - 23 - B4B |
|     |                             |          |         |                     | Packaging 3 - 24 - B4B |
|     |                             |          |         |                     | Packaging 3 - 25 - B4B |
|     |                             |          |         |                     | Packaging 3 - 26 - B4B |
|     |                             |          |         |                     | Packaging 3 - 27 - B4B |
|     |                             |          |         |                     | Packaging 3 - 28 - B4B |
|     |                             |          |         |                     | Packaging 3 - 29 - B4B |
|     |                             |          |         |                     | Packaging 3 - 30 - B4B |
|     |                             |          |         |                     | Packaging 3 - 31 - B4B |
|     |                             |          |         |                     | Packaging 3 - 32 - B4B |
|     |                             |          |         |                     | Packaging 3 - 33 - B4B |
|     |                             |          |         |                     | Packaging 3 - 34 - B4B |
|     |                             |          |         |                     | Packaging 3 - 35 - B4B |
|     |                             |          |         |                     | Packaging 3 - 36 - B4B |
| 150 | QC 21 - SA                  | 8        | 7/26/19 | 0.00 0.00           | QC 21 - SA - 21        |

BE

BE

DAS  
21  
9:55

JUL 2 2 2019

Plex 7/2/19 10:04 AM Dart.lajeunesse.marie

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op **100** - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes  
 Descriptions: to 0.508" as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit  
 inspection saddles on FWD & AFT saddle holes using DT9916.

**101** - (QC5- Inspect part completeness to step on W/O)

**110** - (Chemical Conversion Coat per QSI005 4.1)

**120** - (QC7-Inspect Chemical Conversion Coat)

**125** - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: 5174392 Sikaflex expire  
 date: 08/12/2019 Start time and date: \_\_\_\_\_ bond for 12hrs

**130** - (QC5- Inspect part completeness to step on W/O)

**140** - (Identify as per dwg & Stock Location: LG003) LOCATION : LG002

**150** - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item | Component Name          | Quantity     | Operation               | Container                           |
|-------------|-------------------------|--------------|-------------------------|-------------------------------------|
| D2500-1-190 | Ext'n -'I' Beam Tube 4" | 8 pcs (1 ea) | 100-Skidtubes - 1       | <u>5168371</u>                      |
| D2596       | Web, 205 Skidtube       | 8 pcs (1 ea) | 125-Skidtubes - 2 - B4B | <u>5196746 X6</u><br><u>5186697</u> |

### Job Allocations

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Skidtubes - 1       | D2500-1-190    | 8        | 83        | 0         |
| 125-Skidtubes - 2 - B4B | D2596          | 8        | 10        | 0         |

### Part Specifications

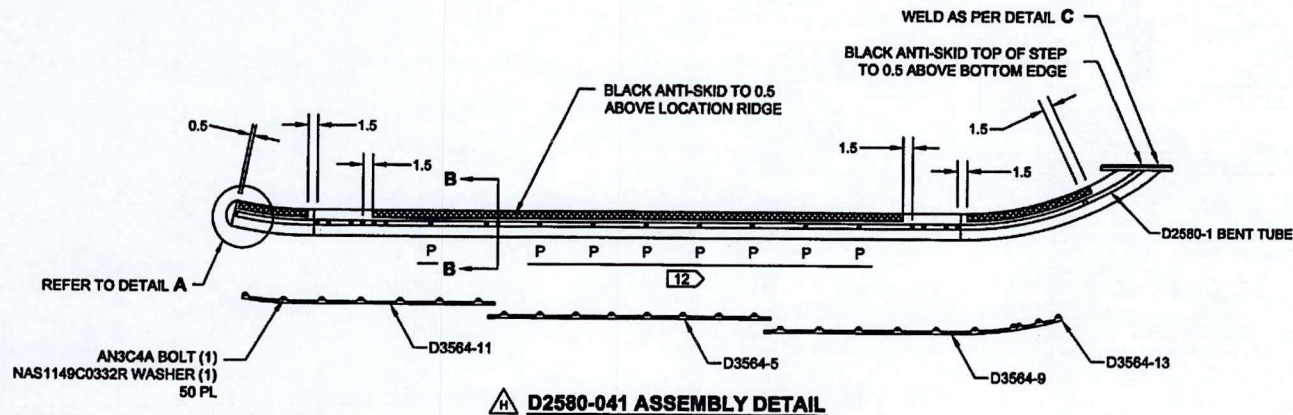
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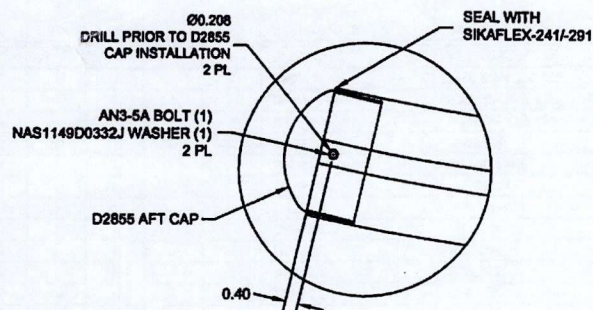




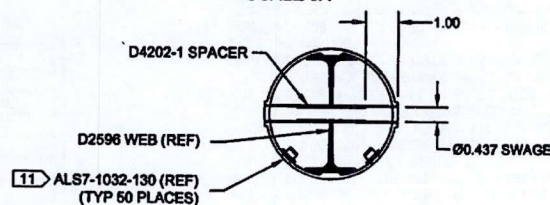




**DETAIL A**  
SCALE 5X

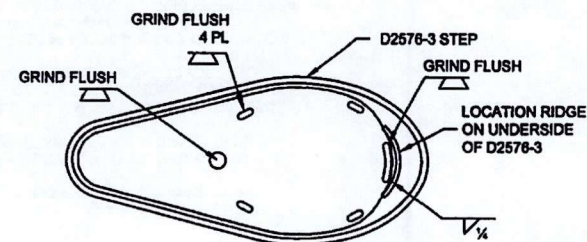


**SECTION B-B**  
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

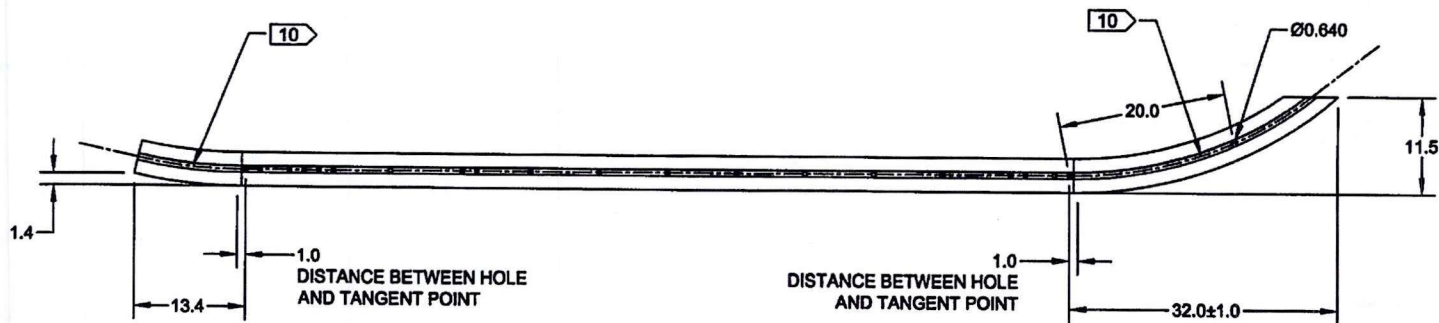
**DETAIL C**  
SCALE 5X



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|                                                                                                                                                                                                                                |                    |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------------------|--------------|
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| MFG. APPR.                                                                                                                                                                                                                     | <i>[Signature]</i> | D2580                                  | SHEET 2 OF 9 |
| APPROVED                                                                                                                                                                                                                       | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                  | NTS          |
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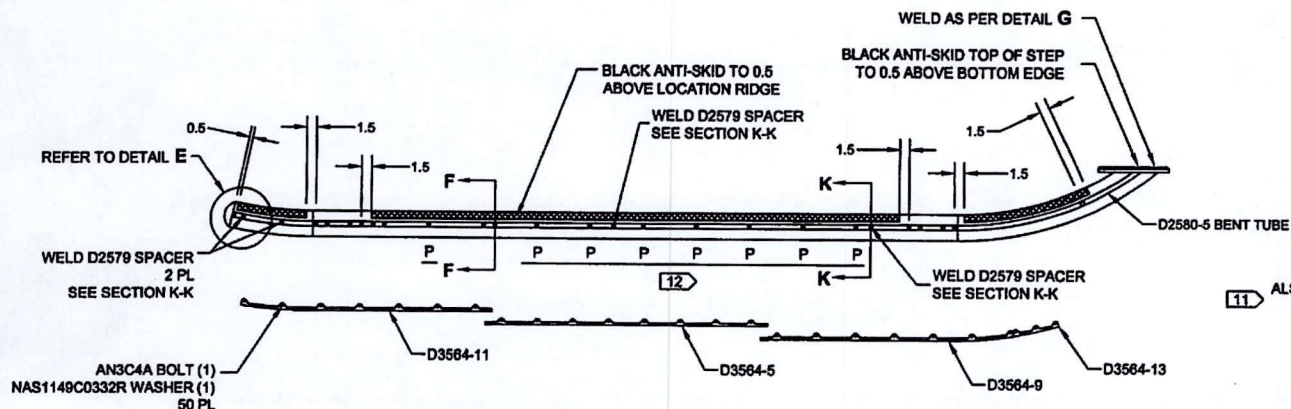


**D2580-1 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

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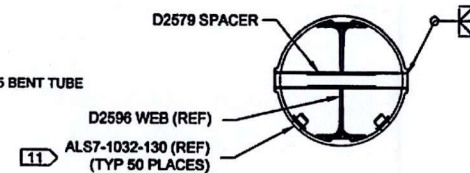
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| DRAWN      | SAD                |                                                                                                                                                                                                                                                                               |                        |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.<br>D2580                                                                                                                                                                                                                                                          | REV. H<br>SHEET 3 OF 9 |
| MFG. APPR. | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                         | SCALE                  |
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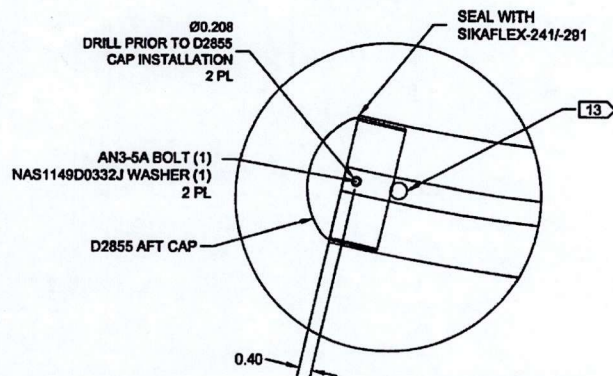
**D2580-045 ASSEMBLY DETAIL**

**SECTION K-K  
SCALE 5X**

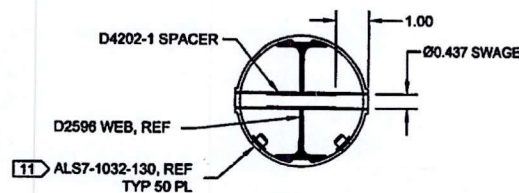


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (4 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. DO NOT C'BORE

**DETAIL E  
SCALE 5X**

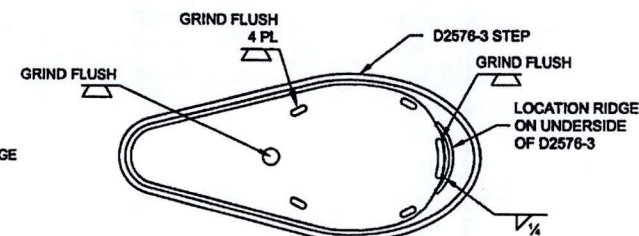


**SECTION F-F  
SCALE 5X**



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (20 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002

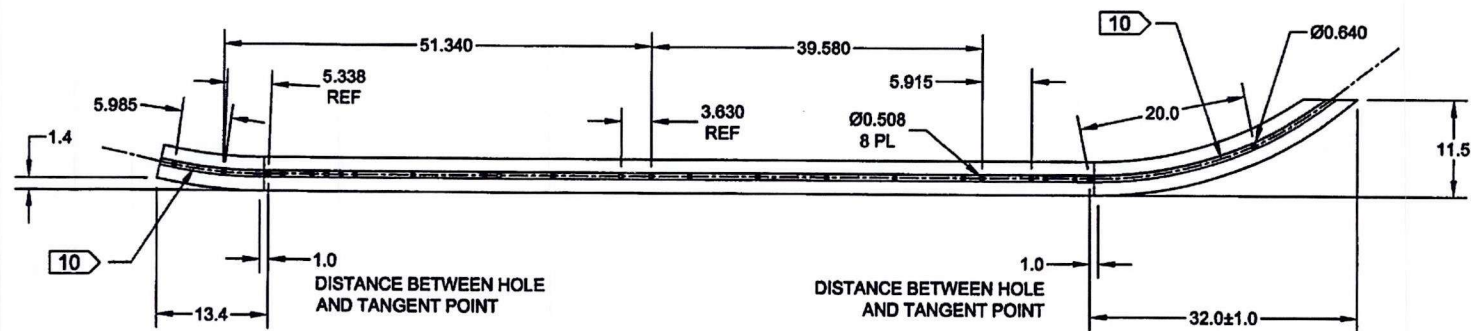
**DETAIL G  
SCALE 5X**



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| MFG. APPR.                                                                                                                                                                                                                     | <i>[Signature]</i> | D2580                                  | SHEET 4 OF 9 |
| APPROVED                                                                                                                                                                                                                       | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                  | NTS          |
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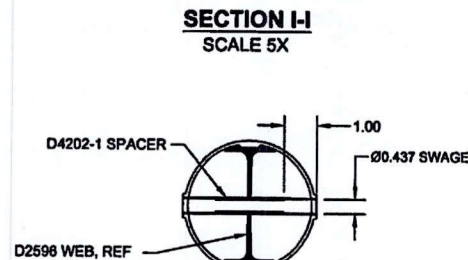
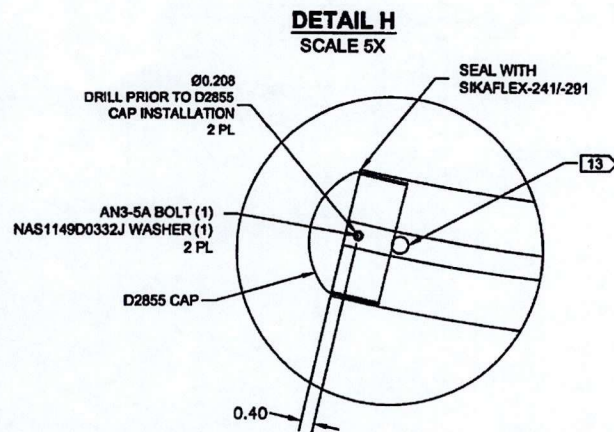
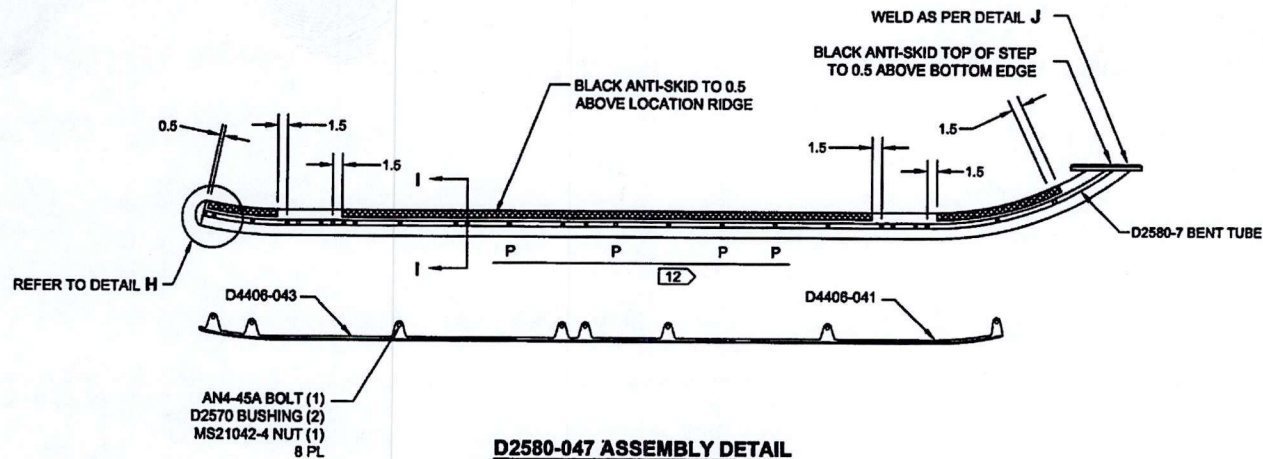


**D2580-5 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

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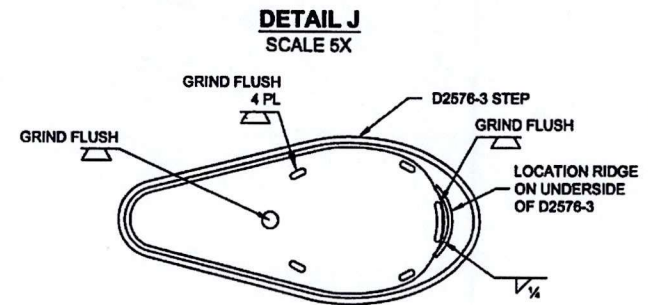
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|            |           |                                                                                                                                                                                                                                                                                                  |              |
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| MFG. APPR. | <i>JS</i> | D2580                                                                                                                                                                                                                                                                                            | SHEET 5 OF 9 |
| APPROVED   | <i>JS</i> | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | <i>JS</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                            | NTS          |
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AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

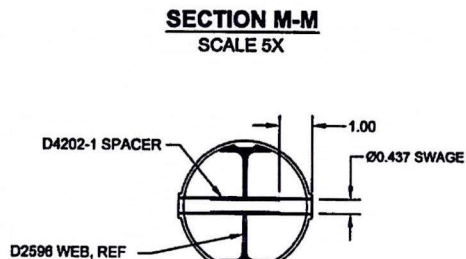
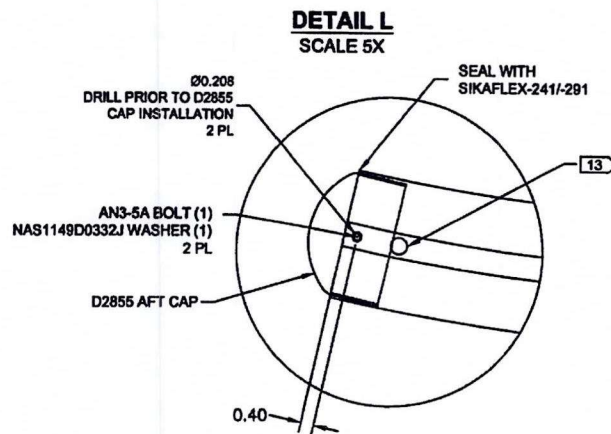
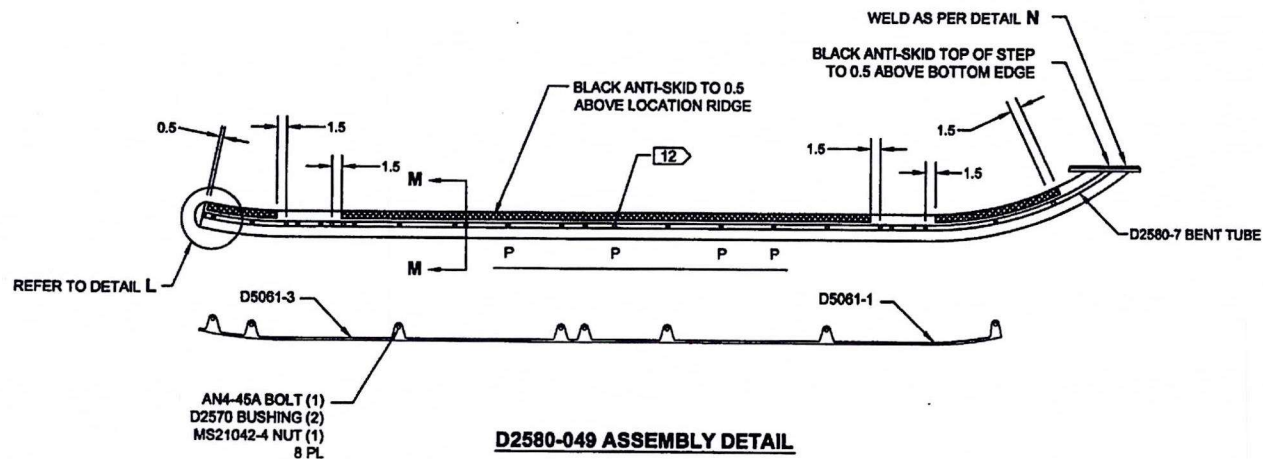


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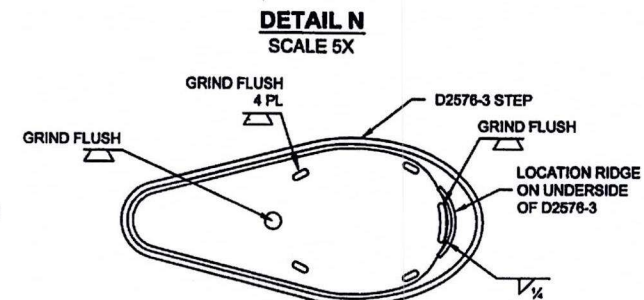
2017 JUL 05

|            |                    |                                                                                                                                                                                                                                                                         |              |
|------------|--------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                               |              |
| DRAWN      | SAD                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                             |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO. D2580                                                                                                                                                                                                                                                       | REV. H       |
| MFG. APPR. | <i>[Signature]</i> |                                                                                                                                                                                                                                                                         | SHEET 8 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                   | NTS          |
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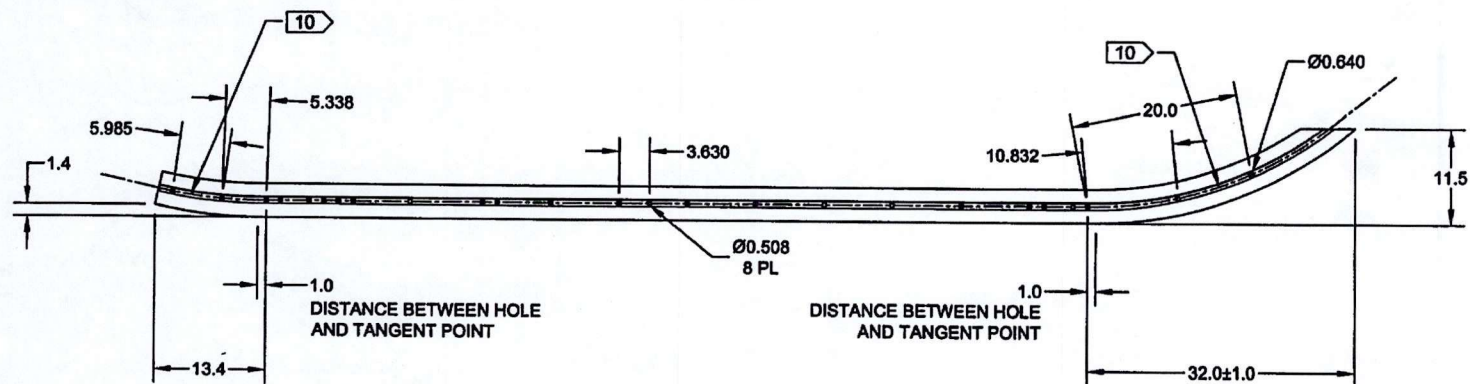
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4202-1 SPACER (24 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM/GRIND FLUSH PER QSI 002



RELEASED

2017 JUL 05 up

|            |                    |                                                                                                                                                                                                                                                                                                  |              |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b><br>HAWKESSBURY, ONTARIO, CANADA                                                                                                                                                                                                                                        |              |
| DRAWN      | SAD                |                                                                                                                                                                                                                                                                                                  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.<br>D2580                                                                                                                                                                                                                                                                             | REV. H       |
| MFG. APPR. | <i>[Signature]</i> |                                                                                                                                                                                                                                                                                                  | SHEET 7 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE<br>205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                   | SCALE<br>NTS |
| DE APPR.   | <i>[Signature]</i> |                                                                                                                                                                                                                                                                                                  |              |
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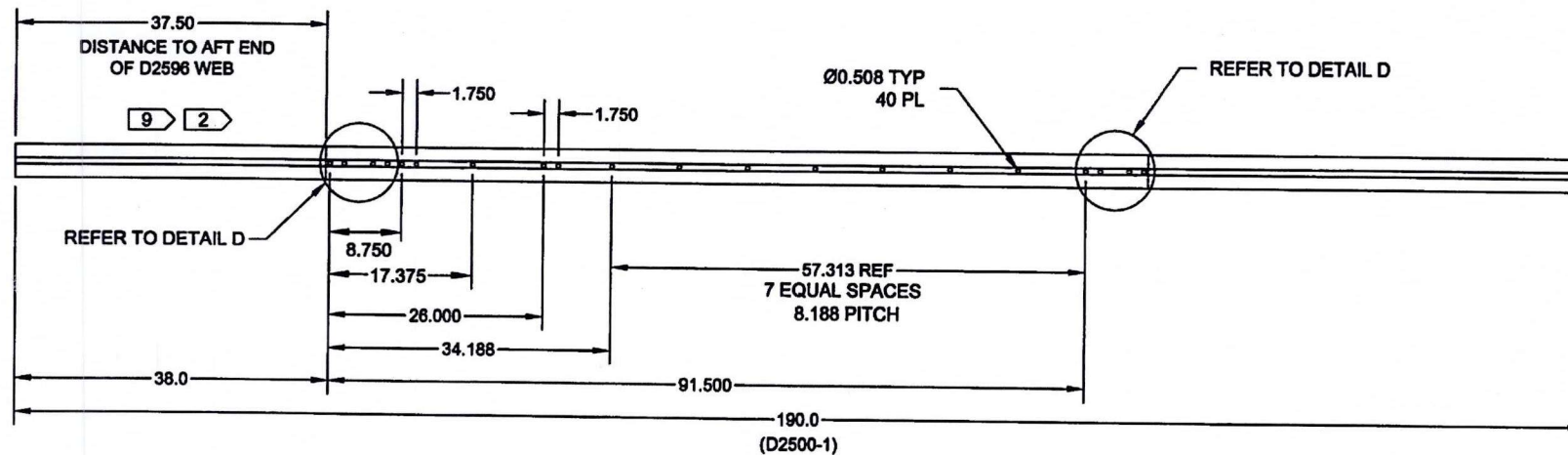


**D2580-7 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

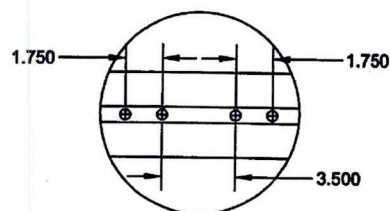
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2017 JUL 05

|            |                    |                                                                                                                                                                                                                                                                                                  |              |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      | SAD                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                                            | SHEET 8 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                            | NTS          |
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**D2580-101 TUBE**



**DETAIL D**  
SCALE 5X

**RELEASED**

2017 JUL 05

|            |                    |                                                                                                                                                                                                                                                                                   |              |
|------------|--------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                          |              |
| DRAWN      | SAD                |                                                                                                                                                                                                                                                                                   |              |
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| MFG. APPR. | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                                             | SHEET 9 OF 9 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                             | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                             | NTS          |
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8 7 6 5 4 3 2 1



## Route update only

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J